

Date: Wednesday, 25/06/2008 3:26:18 PM
 User: Julie Lecocq

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: 20 DEGREE COVER PLATE
Job Number	: 40094	Part Number	: PB674300173
Estimate Number	: 13384	Drawing Number	: B6743001 PAGE26
P.O. Number	:	Project Number	: N/A
This Issue	: 25/06/2008	Type	: SMALL /MED FAB
Prsht Rev.	: NC	Drawing Revision	: B1
First Issue	: / /	Material	:
Previous Run	: 40070	Due Date	: 04/07/2008
Written By	:	Qty:	10
Checked & Approved By	: <u>JUL 01.6.25</u>	Um:	Each
Comment	: Est Rev:A 08-06-19 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S032	6061-T6 Sheet 0.032"
		16
	Comment: Qty.: 1.0692 sf(s)/Unit Total : 10.6922 sf(s) 6061-T6 Sheet 0.032" batch: <u>16954</u>	
		<u>HB 8-6-26</u>
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg B67-43001 Dwg Rev: <u>B1</u> Prog Rev: <u>B1</u>	
		<u>HB 8-6-26</u>
		(D)
	****grain direction along 6.950" ****	
	2-Deburr if necessary	<u>HB 8-6-26</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	<u>S 08/06/06</u> <u>(+12)</u>
5.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE Bend as per Dwg B67-43001	<u>SB 08/07/02</u> <u>(+12)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/07/14								

NOTE: Date & initial all entries

Date: Wednesday, 25/06/2008 3:26:18 PM
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Process Sheet

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Drawing Name: 20 DEGREE COVER PLATE

Job Number: 40094

Part Number: PB674300173

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S080707 X12

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-weld as per dwg B67-4300

Pd 08-07-03 X12

8.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-grind weld flush

SDM 08/07/10 X12

9.0 QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S080714 X12

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S080714 X12

11.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Mf 08-07-16 X12

12X

12.0 POWDER COATING

POWDER COATING



M102316

Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

1:45 pm

OVEN TEMPERATURE:

320°

FINISH TIME:

2:15 pm

20

08-07-16

X12

13.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 08-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-73 PAR #: _____ Fault Category: Prod/Lk. M Fpb. NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR: 40094		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/14 # 80	During welding inspection one part was found with a crack in the weld R.C. too hot at a weld and too much grinding	QTY 1 Destroy no replace	SCRAP card	SAB	08/07/14			
08/07/14 # 80	two parts were also found to need welding touch ups due to pin holes and not enough	QSA12	Touch up welds as per QS7004 and grind flush	PJ 08-07-14	C 08/07/14			

NOTE: Date & initial all entries

Root in some sections
of the weld.

Date: Wednesday, 25/06/2008 3:26:18 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 20 DEGREE COVER PLATE

Job Number: 40094

Part Number: PB674300173

Job Number:



Seq. #: Machine Or Operation:

Description :

14.0 PG PURCHASING



Comment: PURCHASING

SEND TO TALMAR FOR FOAM AND FABRIC

9/08/08 6866

C08108105

(12)

15.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

180810819 (12)

16.0 QC6 DIMENSIONAL CHECK



POSITIVE RECALL

EFFECTIVE 08/08/08 AUTH 14

08/08/08/21 (12)

Comment: DIMENSIONAL CHECK

RELEASED 08/08/08 AUTH 14

08/08/08/21

17.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

39952

18.0 QC21 FINAL INSPECTION/W/O RELEASE



08/08/21 ff

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

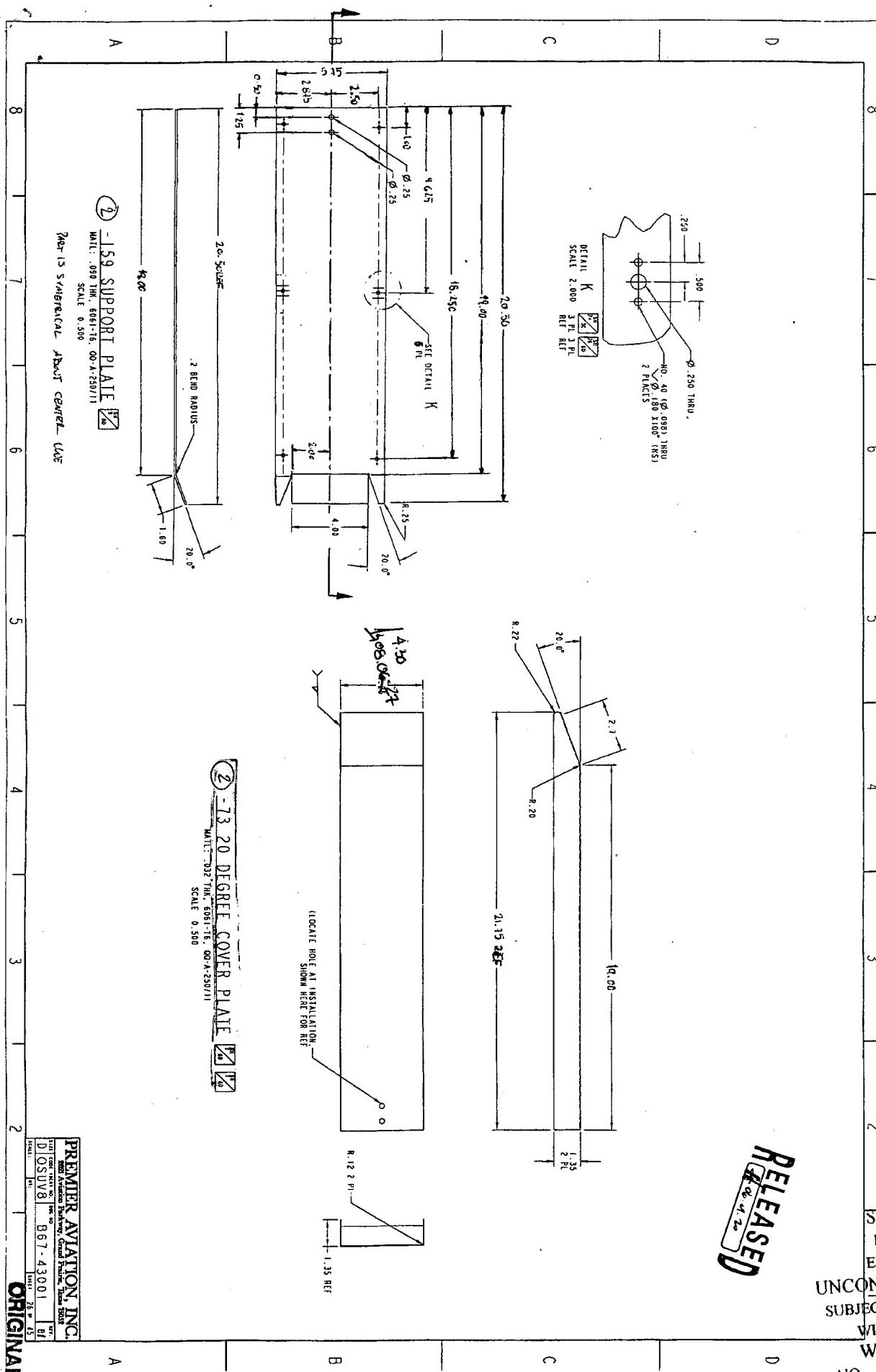
NOTE: Date & initial all entries

8
7
6
5

4

SHOP COPY
RETURN TO
ENGINEERING

~~UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4009~~



DART AEROSPACE LTD	Work Order:	40094
Description: 20° COVER PLATE	Part Number:	PB6743001-73
Inspection Dwg:	Rev: B	Page 1 of 1

PB 6743001-73

FIRST ARTICLE INSPECTION CHECKLIST

X First Article | Prototype

Measured by:	B	Audited by:	D	Prototype Approval:	C / 7
Date:	8-6-2L	Date:	08/06/26	Date:	/ /

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



PACKING SLIP

TULMAR

Tulmar Safety Systems Inc.

1123 Cameron Street
Hawkesbury, ON K6A 2B8 CA
Tel: 613-632-1282
Fax: 613-632-2030
MID : CATULSAF1123HAW
email: info@tulmar.com

Bill No:

Dart Aerospace
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7. Canada

COPY

Packing Slip No.

29809

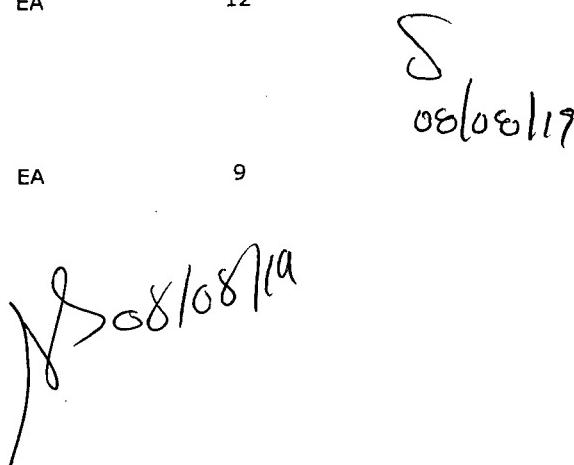
Ship Date

19-Aug-08

Ship To:

Dart Aerospace
1270 Aberdeen Street
Buyer= C Lavoie
Tel: 613-632-9577
Hawkesbury, ON K6A 1K7. Canada
613-632-9577

Order No.	Order Date	Customer No.	Sales Rep.	Release Note No.
21729	6-Aug-08	CDART100	Barney Bangs	R92- 29809
Customer PO Number		Ship Via	PPD/COL	Qty Backordered
Item No.	Qty	Pick-Up	UOM	Qty Shipped/Returned
Description				
Date moved out to 09/15/08 due to material shortage 1637-001 foam				
8421-109	5	EA	5	
Dart Blade Fold Kit - Pad #10/ Drawing No: (Ref B67-43001-35 Rev B1) DWG Rev: A				
Lot No: BATCH0000000003 Qty: 5				
8421-107	5	EA	5	
Dart Blade Fold Kit - Pad #8/ Drawing No: (Ref B67-43001-33 Rev B1) DWG Rev: NR				
Lot No: BATCH0000000003 Qty: 5				
8421-105	12	EA	12	
Dart Blade Fold Kit - Pad #6/ Drawing No: (Ref B67-43001-73 Rev B1) DWG Rev: A				
Lot No: BATCH0000000002 Qty: 12				
8421-106	9	EA	9	
Dart Blade Fold Kit - Pad #7/ Drawing No: (Ref B67-43001-69 Rev B1) DWG Rev: A				
Lot No: BATCH0000000002 Qty: 9				


 S
 08/08/17
 J. So 8/08/17



RELEASE NOTE

TULMAR

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawkesbury, ON K6A 2B8 CA
Tel: 613-632-1282
Fax: 613-632-2030
MID : CATULSAF1123HAW
www.tulmar.com
email: info@tulmar.com

Bill No:

Dart Aerospace
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7. Canada

COPY

Release Note No.
R92-29809
Ship Date

19-Aug-08

Ship To:

Dart Aerospace
1270 Aberdeen Street
Buyer= C Lavoie
Tel: 613-632-9577
Hawkesbury, ON K6A 1K7. Canada
613-632-9577

Order No.	Order Date	Customer No.	Sales Rep.
21729	6-Aug-08	CDART100	Barney Bangs
Customer PO Number		Ship Via	Packing Slip No.
PO000006866		Pick-Up	29809
Item No.	Qty	UOM	Qty Shipped/Returned
Description			Qty Backordered
8421-107 Dart Blade Fold Kit - Pad #8/ Drawing No: (Ref B67-43001-33 Rev B1) DWG Rev: NR	5	EA	5
Comments: Lot No: BATCH0000000003 Qty: 5			
8421-109 Dart Blade Fold Kit - Pad #10/ Drawing No: (Ref B67-43001-35 Rev B1) DWG Rev: A	5	EA	5
Comments: Lot No: BATCH0000000003 Qty: 5			
3421-106 Dart Blade Fold Kit - Pad #7/ Drawing No: (Ref B67-43001-69 Rev B1) DWG Rev: A	9	EA	9
Comments: Lot No: BATCH0000000002 Qty: 9			
3421-105 Dart Blade Fold Kit - Pad #6/ Drawing No: (Ref B67-43001-73 Rev B1) DWG Rev: A	12	EA	12
Comments: Lot No: BATCH0000000002 Qty: 12			

08/08/19

RELEASE NOTE

TULMAR

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawkesbury, ON K6A 2B8 CA
Tel: 613-632-1282
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MID : CATULSAF1123HAW
www.tulmar.com
email: info@tulmar.com

Bill No:

Dart Aerospace
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7. Canada

COPY

Release Note No.

R92-29809

Ship Date

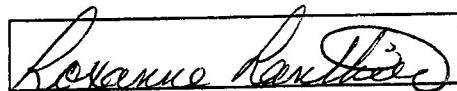
19-Aug-08

Ship To:

Dart Aerospace
1270 Aberdeen Street
Buyer= C Lavoie
Tel: 613-632-9577
Hawkesbury, ON K6A 1K7. Canada
613-632-9577

If any questions or concerns, please contact QA Manager @ 613-632-1282 ext. 245.

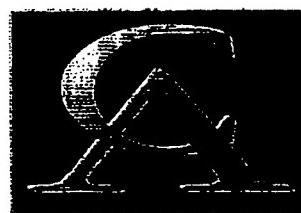
This release note is a Certificate of Conformance and I hereby certify that the items listed hereon have been inspected, tested and conform to all specifications and requirements detailed in the contract or purchase order. Objective evidence to support this release note is on file, and can be made available upon request.



Authorized Inspector

08/19/2008

Date



CLIFTON Adhesive, Inc

Industrial Adhesives & Coatings

Date: 6/24/08

Shipper #: 10307

Certificate of Compliance

This letter certifies that 11 x 5 gallon pails of LA4009 Adhesive,
lot number (s) 08-158 was shipped to you on 6/24/08.

Clifton Adhesive, Inc manufactured this material according to internal specifications
which include quality control and assurance procedures. The material was
manufactured on 6/6/08 against your Purchase Order # 14304-00.

Shelf Life: 1 year from date of manufacture
Expiration Date: 6/6/09

This letter certifies that 4 x quart cans of CATUR Accelerator,
Lot number 08-156 was shipped to you on 6/24/08.

Clifton Adhesive, Inc manufactured this material according to internal specifications
which include quality control and assurance procedures. The material was
manufactured on 6/4/08 against your Purchase Order # 14304-00.

Shelf Life: 1 year from date of manufacture
Expiration Date: 6/4/09

Sincerely,

Dan Constantino

Daniel Constantino
Quality Assurance Mgr/ISO Coordinator

Burgess Place - Wayne, NJ 07470 USA
Phone: 973-694-0845 - Fax: 973-694-5678
www.cliftonadhesive.com

TSS # 7/22/22 (S)



J. ENNIS FABRICS LTD.

Wholesale Distributor of Textiles and Supplies

October 20, 2006

Fax To: Tulmar Safety Systems
Fax: 613-632-2030
Attention: Sandra Nadeau
Fax From: Deanna Penner

EDMONTON
HEAD OFFICE
12122-68 Street
Edmonton AB T5B 1R1
Canada
Phone: (780) 474-5721

TORONTO
6800 Kennedy Drive
Mississauga ON L5T 2N3
Canada

CALGARY
2nd Floor 337-17 Avenue SW
Calgary AB T2S 0A5
Canada

VANCOUVER
13911 Bridgeport Road
Richmond BC V6V 1J8
Canada

Certificate of Conformance

Re: PO 11878 for Oxford 7 Black

The goods shipped on P/O 11878 are as per sampled goods. Specification as follows:
As per mill documentation:

Oxford is in compliance with the following standards:

Width: Product is 58 Inches Wide.

Roll Size: Average Roll Length is 75 Yards.

Weight: Product Weight is 6.79 Ounces per Sq.Yd. /Product Weight is 10.94 oz per Lin.Yd

Content: 100% Nylon

Coating: Product has a Polyurethane Coating (approximately 0.65 oz/ Sq.Yd. (18.5g/sq.yd.))

Denier: Yarn is 420 Denier.

Thread Count: Construction is 62 x 38 Threads per Square Inch

Protective Finish: Product is Water Repellent.

Hydro Resist: AATCC 127 (Suter): Average 800 mm

Manufacture Date: 1) 50 yds each 9/11/06 Piece # 101629822, 101629830, 101629848,
101630226, 101630234, 101630275 & 101630283 &
2) 50 yds each 10/12/06 Piece # 101734465, 101734473, 101734481, 101734499 & 101734507.

Lot Number: 1) 50 yds each, #217079 Piece # 101629822, 101629830, 101629848, 101630226,
101630234, 101630275 & 101630283
2) 50 yds each, #221709 Piece # 101734465, 101734473, 101734481, 101734499 & 101734507.

Sincerely:
J. Ennis Fabrics Ltd.

D. Penner

Deanna Penner
Product Development

English: 1-800-66-ENNIS

Fax: (780) 479-6135
www.jennisfabrics.com

Français: 1-888-66-ENNIS

TSS # 1495 / 10

E.F. Walter Inc.	CERTIFICAT DE CONFORMITÉ CERTIFICATE OF COMPLIANCE	Approved <u>JR</u> Date <u>1/3/02</u>
Revision # 0	Revision date: January 30, 2002 Doc # F.7.5.5.A	Page 1 of 1

VENDU À
SOLD TO6048

TULMAR SAFETY SYSTEMS INC.
1123 CAMERON STREET
HAWKESBURY ONT
K6A 2B8

FOURNISSEUR
VENDOR

E.F. WALTER INC.
5000 HICKMORE
ST. LAURENT, PQ
H4T 1K6

Date : 07/15/2005

Commande / Order # 10280
 Notre / Our Reference # 37736

Nous certifions par la présente que la totalité du matériel inscrit ci-dessous a été inspecté et vérifié et est conforme aux devis et aux normes mentionnés sur votre commande.

We hereby certify that all of the material listed below has been inspected and tested and conforms to the drawings and / or specifications stated on your purchase order.

Item	Quantité Quantity	Piece # Part #	Description
742050004	10.00 SH		SC42 BLACK NEOPRENE UNTRIMMED 1/2" X 42" X 72' (NO SKIN) ASTM D1056 2A2
742012002	5.00 SH		SC42 BLACK NEOPRENE UNTRIMMED 1/8" X 42" X 72' (NO SKIN) ASTM D1056 2A2
			FLAME RESISTANCE
			SERVICE TEMP -40 DEG F TO +200 DEG F

Signé
Signed

July 15, 2002

RS #1637-001/01 (a)



cansew inc.

formerly / anciennement
Canadian Sewing Supply Ltd. / Ltée - established / établie 1924

Manufacturers of sewing threads. / Wholesalers of elastics, Velcro, tapes, trimmings.
Fabricants de fils à coudre. / Grossistes d'élastiques, Velcro, galons, garnitures.

3 January 2007

Tulmar Safety Systems
1123 Cameron Street
Hawkesbury, Ontario
K6A 2B8

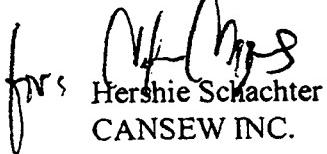
Att. Sandra Nadeau

CERTIFICATE OF COMPLIANCE

This is to certify that the items mentioned below, shipped to Tulmar Safety Systems by CANSEW INC. on 3 January 2007, have been produced in accordance with the requirements of Purchase Order no. 12195-00 of the same date:

- Bonded Nylon CBB92, colour OG107, V-T-295, Type 2, Class A, Size F – 50.94 lb (60 cones), lot nos. 596136-603456
- *-Bonded Nylon CBB92, colour black, V-T-295, Type 2, Class A, Size F – 17.59 lb (20 cones), lot no. 623130
- Bonded Nylon CB207, colour black, V-T-295, Type 2, Class A, Size 3 – 19.48 lb (20 cones), lot no. 634807

Yours truly,


Herschie Schachter
CANSEW INC.

MONTRÉAL - Head Office/Siège social
111 Chabanel W / O H2N 1C9
Administration (514) 382-2807
Commandes/Orders (514) 382-2801
1-800-361-7722
FAX: (514) 385-5530

TORONTO
28 Apex Rd. M6A 2V2
(416) 782-1122
1-800-387-8584
FAX: (416) 782-8358

WINNIPEG
1674 Church Ave R2X 2W9
(204) 942-4264
1-800-665-0701
FAX: (204) 947-9280

CALGARY
3932 - 29th St. N.E. T1Y 6B6
(403) 291-4494
1-800-667-4197
FAX: (403) 291-5139

VANCOUVER
1615 Venables St. V5L 2H1
(604) 682-4341
1-800-580-0737
FAX: (604) 682-4196

info@cansew.ca

www.cansew.ca

TCC # 2520/13

(62)